

Work Order ID 126920

126920

Page 1

Monday, December 01, 2014 11:33:28 AM

Item ID: D3822-5KGY

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Vertical Tunnel, Top

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 14-12-1 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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d3822-5	Rev C
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100

0.00

DAS
07
9-89

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x3

14/12/14

105

0.00

DAS
07
9-89

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150 deg. F

Time IN: 5:00 PM

Time OUT: 6:00 AM

DEC 15 2014

Per... [Signature]

x3

14/12/14

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Monday, December 01, 2014 11:33:28 AM

Item ID: D3822-5KGY Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Vertical Tunnel, Top
 Start Date: 11/27/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							07 9-89
110		0.00				x 3			14/12/16
Thermoform	Memo								
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA028 using tool DT9078								
	Dwg Rev: C								
	Folio Rev: B								
	Visually inspect for proper formation of each part								
140		0.00							DAG 07 9-89
140		0.00				x 3			14/12/18
HandThermo	Memo								
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

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Item ID: D3822-5KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Vertical Tunnel, Top

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14/12/18 JF
ME
14-12-18

Picklist Print

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Work Order ID: 126920

126920

Parent Item: D3822-5KGY

D3822-5KGY

Parent Item Name: Vertical Tunnel, Top

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No		100	sf	3,800.000	0.71	1			DAS 07 9-09

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

**

17/12/18

Location	Loc Qty	Loc Code
LAIRD	1180	
m129546	347	
m129760	347	
m130383	486	
therm	2620	
119476	61	
121902	819	
122181	1046	
m127759	347	
m128321	347	

x 3 sz pt

DART AEROSPACE LTD		Work Order:	126920
Description: Vertical Tunnel, Top		Part Number:	D3822-5KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS 07
9-89

Date: 14/12/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	Min	0.325"	✓			
0.040	Min	0.046"	✓			
0.060	Min	0.073"	✓			

Measured by: DAS 07
9-89

Audited by: DAS 38
9-89

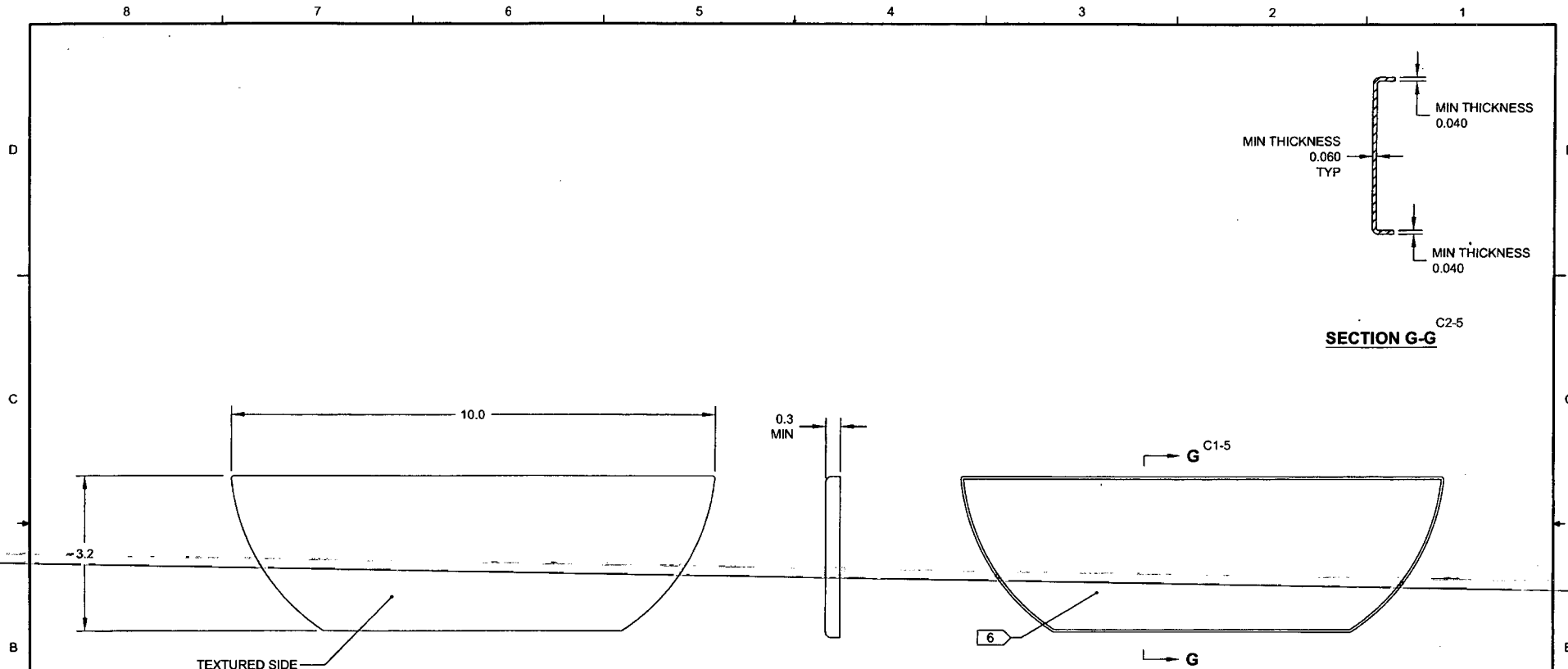
Prototype Approval: N/A

Date: 14/12/16

Date: DEC 13 2016

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	



D3822-5 VERTICAL TUNNEL, TOP
(BELL 206 A/B)

RELEASED
9/15/12 M

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 6) WEIGHT: 0.12 lbs
- 7) TOOLING: THERMOFORM PER MOLD DT9078 PER DART QSI 022



PART NUMBER	DESCRIPTION
D3822-5KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-5KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	10	DART AEROSPACE LTD
DRAWN	10	HAWKESBURY, ONTARIO, CANADA
CHECKED	10	DRAWING NO. REV. C
MFG. APPR.	10	D3822 SHEET 5 OF 6
APPROVED	10	TITLE SCALE
DE APPR.	10	VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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